

43

Date: Thursday, 11/29/2007 11:04:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 36027	
Estimate Number : 10267	
P.O. Number :	Part Number : D2438
This Issue : 11/29/2007 S.O. No. :	Drawing Number : D2438 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 33937	Material :
Written By :	Due Date : 12/20/2007 Qty: 200 Um: Each
Checked & Approved By : <u>JA 07.11.29</u>	
Comment : Est. E 05.06.28 Bending removed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING
Issue P/O: 5169
Laser cut as per Dwg D2438
Material release note is required

CL 07/11/30

200

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)
CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

Rec'd 4/18

200

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D2438
(6.786" center to center)

QSP019

508/02/15

counts
200

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr any rough edges

508/03/06

200

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:04:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 36027

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (200)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 456

DS 08/03/06 (200)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/07 (200)

Job Completion



mi 2008/3/07 (200)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

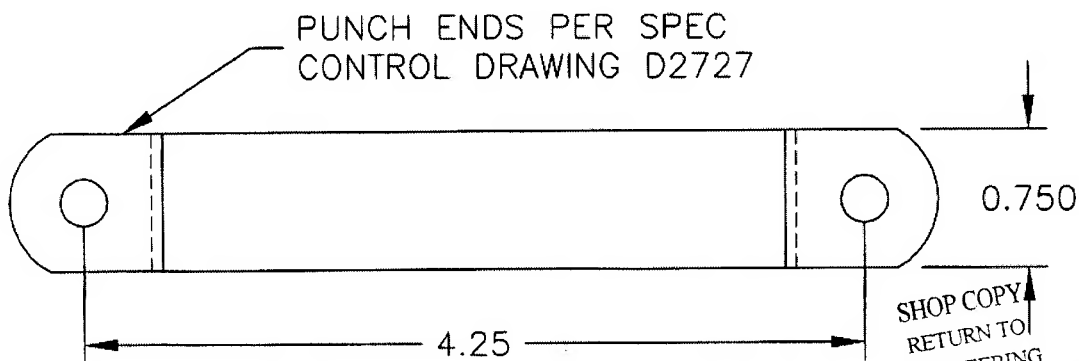
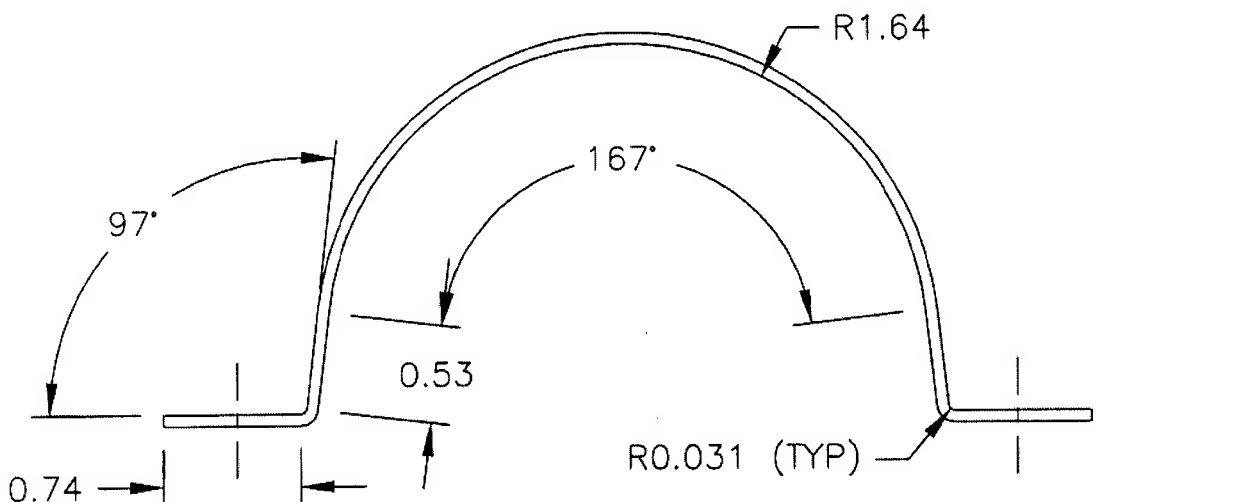
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
43.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36027

00.06.06
CP 00.06.07



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/02/14	0385688

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO	N° COMMANDE PO NO	VIA SHIP VIA
DART GFI-0299	J0175481	PO00005169	

QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO	DESCRIPTION
200	D2438B	CLAMP CUT&FORMED C OF C REQ'D

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **14** OUR JOB NO. **J0175481** SHIPPING MEMO **0385688**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
200 PCS	PO00005169	D2438B	C	CLAMP	C	

MATERIAL **S.S.T 304** SUPPLIED BY **TW METALS / NORTH AMERICAN** MAT. REL. NO. **2MW9**

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **15 FEBRUARY 2008**

G.F.I. Q.C. REP.

Calvin H. M.

~~SP12-001 Rev 0 Bombardier Certificate of Compliance~~
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME: GFI

PURCHASE ORDER No. 0072863

ITEM No. 0001

SHIPPER INVOICE No. 03229748

MATERIAL: 304-5/5 sheet SPECIFICATION: AMS 5511 H

MANUFACTURING MILL: North American Stainless

SIZE: 0625 HEAT / LOT No. 2MA9

PART No. TS06348X964A QUANTITY: 1 EA

TEST DEPARTMENT CLERK: Jessie Clark

AUTHORITY

Joe Schab
Director of Quality Assurance



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 364929 03
Customer: 0018 001

Mail To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Ship To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Date: 7/03/2007 Page: 1

Steel: 302/304/304L

Finish: 2B

Your Order: 01010118

NAS Order: AM 0373859 01

Corrosion: ASTM A262/92aE; 1102end-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/06b, 480/06b, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q08766D-AXMG PRN, AM85511H/5513H/55169, AMS, X CRWN MEAS

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; Q08763P Cond A; RoHS Compliant
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
052MA9 BB	* 052MA9 BB	.0620	48.0000	13.140 COIL	1291.0	1	1	

CHEMICAL ANALYSIS CM(Country of Melt) ES(Special) US(United States) ZA(South Africa)

Heat	CM	C	CR	CU	MN	MO	N	NI	P	S	SI
2MA9	US	.025	18.148	.312	1.710	.217	.087	8.125	.025	.011	.340

MECHANICAL PROPERTIES

Product ID #	Coil #	ld oi cz	UTS KSI	.2% YS KSI	ELONG 4-2"	Hard RB	Tail Hard
052MA9 BB	052MA9	P T	92.99	43.35	54.93	86.00	83.08

REVIEWED BY Q.C.
Date 7/3/07 by

TW METALS

TEST

OCT - 5 2007

ACCEPTED BY

REPORTS

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

7/03/2007

FERGUSON METALS, INC.

This is to certify that in accordance with the records in our files the material shipped on you purchase order conforms to the following.
3475 Symmes Road Hamilton, OH 45015

48 X 120
P.O. 49181673
Sales# 01099952
QTY: 88

Size: 304 ANN .0305-.0665 ASTMA 240
Customer: TW METALS INC.
Date: 2/4/09
Shipped: 10/05/07 85913

Authorized Signature

Lynne Harter